

Split - 2

Work Order ID 126746 - 2

126746

Page 1

Item ID: D5123-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clamp Cushion

Start Date: 11/24/2014 Start Qty: 100.00

100

(4)

Cust Item ID:

Required Date: 11/24/2014 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 14-11-24

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D5123

B

100

0.00

100

Mill Conv

Memo

0.00

Conventional Milling Machine

1-Mill as per DWG

DWG REV: B

2-Deburr as required

100

Ø

J.C. L.

14/12/22

DAS

44

14/12/22

9-89

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

100

Ø

J.C. L.

14/12/22

DAS

44

14/12/22

9-89

(4 Taken for R.D. 5319)

PTO

DQA:

Date: 15/01/26



QA Closed:

Date: 15/1/13

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>126746</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D5123-1</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>15-4530</u>		Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14.12.23	100	100	RO.032 IS RO.015 (C8-1)	A.P. 14.12.23	ACCEPTABLE AS IS	J.C.L. 14/12/23		
Doc/Data									
Equip/Tooling <input checked="" type="checkbox"/>									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									
				RC. custom tool was not made properly		fix cutter and inspected by QC.	<input checked="" type="checkbox"/> 14/12/23	14/12/23 DAS 08 9-89	14-12-23 DAS 9 9-89

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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100
100
100

Work Order ID 126746

Monday, November 24, 2014 10:32:32 AM

126746

Page 2

Item ID: D5123-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp Cushion
 Start Date: 11/24/2014 Start Qty: 100.00 ***100*** Cust Item ID:
 Required Date: 11/24/2014 Req'd Qty: 100.00 ***100*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		14/12/23		4	0		DA: 08 8-8
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>EUG</u> Memo	0.00 0.00		USED FOR RD5319		4		SAD 14/12/21	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				MLJ		14-12-24	

ME
14-12-23

Picklist Print

Monday, November 24, 2014 10:32:35 AM

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Work Order ID: 126746

126746

Parent Item: D5123-1

D5123-1

Parent Item Name: Clamp Cushion

Start Date: 11/24/2014

Required Date: 11/24/2014

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP REV:A NEW ISSUE 14/08/08 JLM VERIFIED BY:RQ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-1		Manufactured	No				f	11.9500		44			
D4287-1									**	J.C.L.			
Uhmw U-Channel													

Location

Loc Qty

Loc Code

ST479a

11.95

122562

0.51

125701

11.44

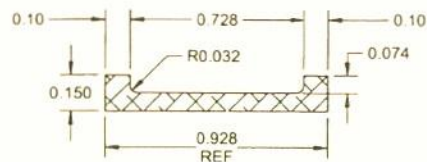
127167

11.44

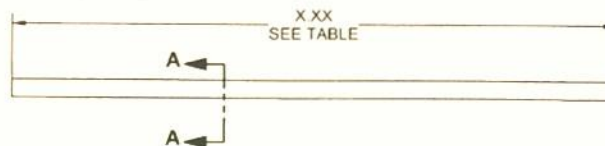
14/12/10

30.63

14/12/18



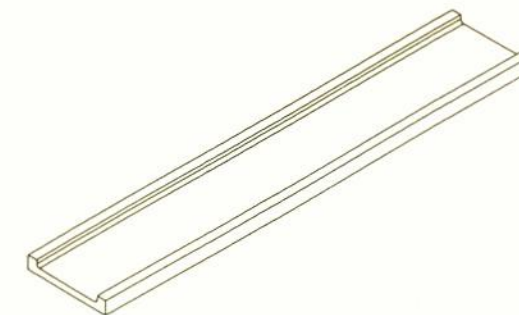
SECTION A-A
SCALE 2X



D5123-Y CLAMP CUSHION

PART NUMBER	LENGTH X.XX (IN)
D5123-1	5.00
D5123-3	4.25
D5123-5	6.00

- NOTES:
- 1) MATERIAL: MAKE FROM D4287-1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.7
 - 7) WEIGHT: LESS THAN 0.01 lbs



126746 ML5
14-11-24

RELEASED
2014-10-08

B	ADDED D5123-5 CLAMP CUSHION, ADDED TABLE, ADDED THICKNESS TO PART	AP	14.08.19
A	NEW ISSUE	AP	14.08.06
REV	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ML	DRAWING NO.	REV. B
MFG. APPR.	JLM	D5123	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	CLAMP CUSHION	NTS
DATE	14.08.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

APPROVED

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